

Date: Friday, 25/07/2008 10:01:35 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D206-558-043
Job Number : 40756 - (Part Number : D206558043
Estimate Number : 10804 Drawing Number : ECN08-504
P.O. Number : Project Number :
This Issue : 25/07/2008 S.O. No. : Drawing Revision :
Prsht Rev. : NC Material :
First Issue : / / Type : SMALL / MED FAB. Due Date : 01/08/2008 Qty: 5 Um: Each
Previous Run : 40748
Written By :
Checked & Approved By :
Comment :

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

3 x D206-558-043 B39284

4 x D206-558-043 B39518

B38414 (42) 08-08-25 FF

44 FF 08-07-31

(4)

2.0

D206558043

Dual Cargo Mirror Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)
Single Cargo Mirror Assembly

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

CUT ARMS TO REMOVE ALL COMPONENTS

D2011-101 MIRROR

D2052 MTG BRKT

D2054 BUSHING

D2055 CLAMP

D2056 BELL CRANK

PUT COMPONENTS ASIDE TO RE-USE WITH NEW ARM

FF 08-07-31 (4)

DISCARD HARDWARE

FF 08-07-31 (4)

MANUFACTURE NEW ARMS WITH .049 WALL MAT'L

DART
Dart Aerospace Ltd.
1270 ABERDEEN ST.
HAWKESBURY, ON, CANADA K6A 1K7

TC APPROVAL # 09-89
TEL: 1-613-632-5200

P/N	D206-558-043	CHG	CHG006
DESC.	Dual Cargo Mirror Assy	STC	SH92-17
LOT	B38414	STC	SH1031NE
MODEL	206A/B/L/L1/L3/L4/407	STC	

MADE IN CANADA D2729-1

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P/N	D206-558-043	CHG	CHG006
DESC.	Dual Cargo Mirror Assy	STC	SH92-17
LOT	B39518	STC	SH1031NE
MODEL	206A/B/L/L1/L3/L4/407	STC	

MADE IN CANADA D2729-1

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MADE IN CANADA D2729-1

Date: Friday, 25/07/2008 10:01:35 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-043

Job Number: 40756

Part Number: D206558043

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 1.7500 f(s)/Unit Total: 12.2502 f(s)

304 RD Tube .500 x .049W

304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012

(M04TR0.500W049)

Identify as D2066

Deburr and Polish

Note: Punch 1 end only at this time

Batch M 108324

SB 08/08/20

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch 1/2" OD x .035" Wall

Slide on parts D2052, D2055, D2056, D2054 as per Dwg D206-558

Note orientation of belcrank and order of parts.

Punch other end to length (28.62") as per Dwg D2066

Use template DT8054

SB 08/08/20

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Flatten the ends on Hydraulic press using DT8545

Bend per Dwg D2066 using template D2066T1

Deburr

Drill 3/16" Dia holes per D2066T1 template and Dwg D2066

Deburr holes

Assemble remaining parts as per Dwg D206-558

USING NEW HARDWARE

SB 09/08/20

SAO FF 08/08/25

7.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~28.0000~~ Each(s)

Washer M 108558

24.0000

FF 08/08/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-558-043 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/08/25
 QA: N/C Closed: _____ Date: _____

NCR: <u>40756</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/08/25</u>	<u>6.6</u>	<u>Missing Part</u> <u>R.C. Dropped on LH</u> <u>flwr.</u>	<u>[Signature]</u>	<u>replace Part</u> <u>AW960JD 416 L</u> <u>M 108136 X2</u>	<u>SAD</u> <u>08/08/24</u>	<u>S</u> <u>08/08/25</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 10:01:35 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-043

Job Number: 40756

Part Number: D206558043

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~14.0000~~ Each(s)
Nut *m 108747* *12.0000*

FF 08/08/25

9.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~14.0000~~ Each(s)
Screw *M108161* *12.0000*

FF 08/08/25

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/25

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS
ENSURE ORIGINAL KIT IN BOX

S 08/08/25

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D206-558-043
USING NEW B/N
NEW LABELS REQUIRED AT CHG 007
ADD PAPERWORK DSI 9416 TO KIT
Location: *12*
PPP Rev: *9*

8/8/25

08/08/25

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

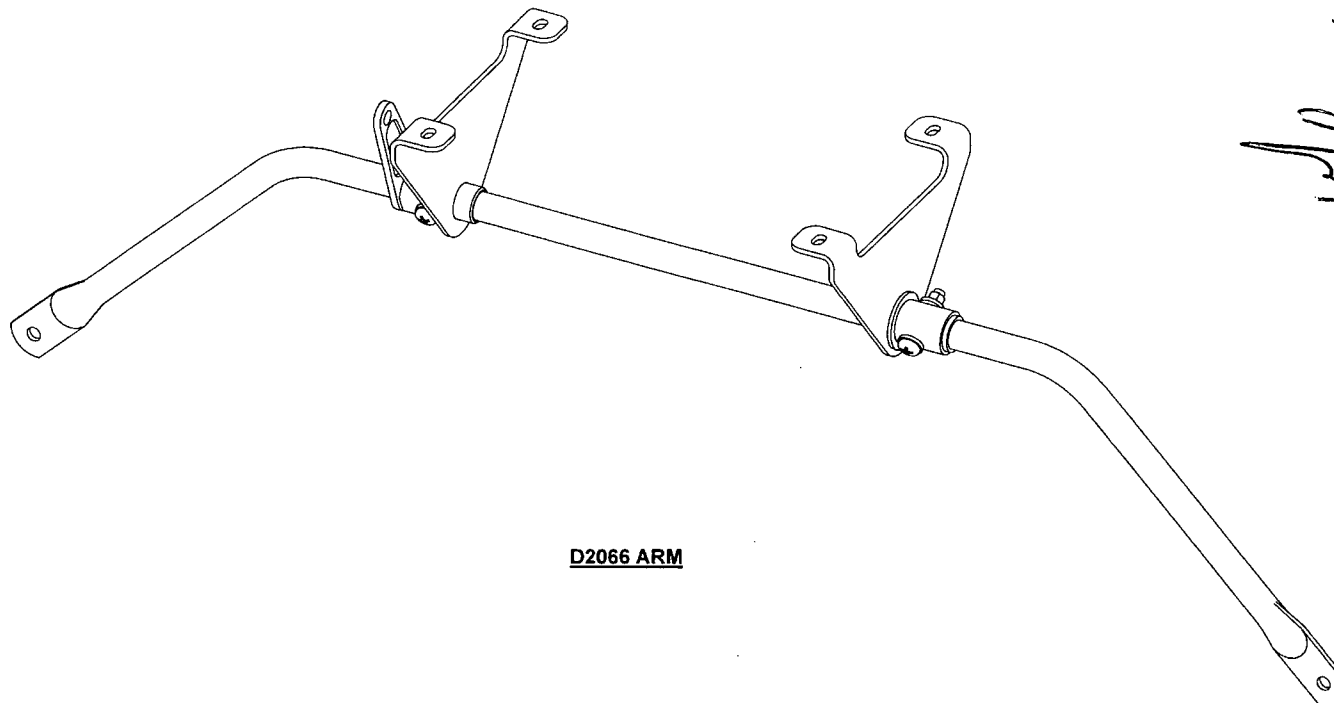
08/08/25

Job Completion



U 28/08.26

8 7 6 5 4 3 2 1

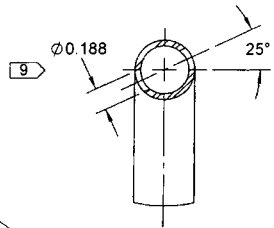


D2066 ARM

RELEASED
08-07-25/10

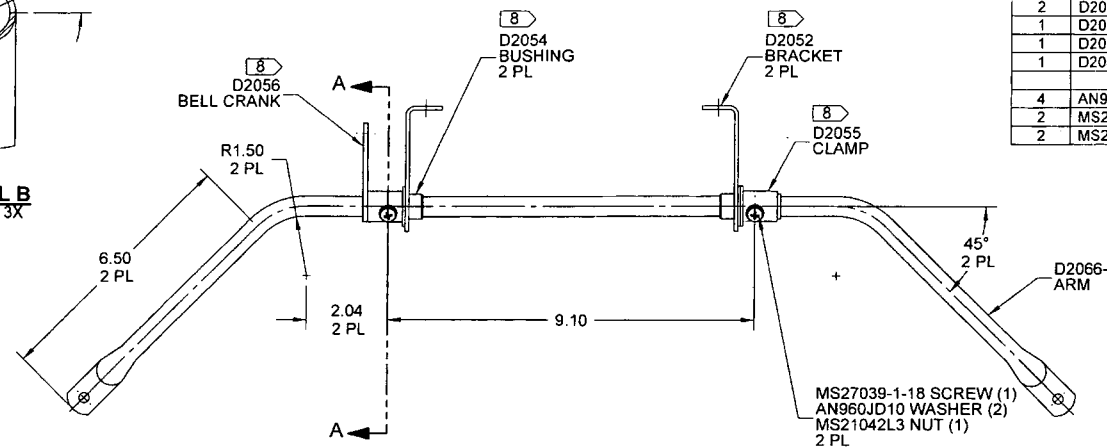
- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.85 lbs

C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066; Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D2066	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ARM	NTS
DATE	08.06.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

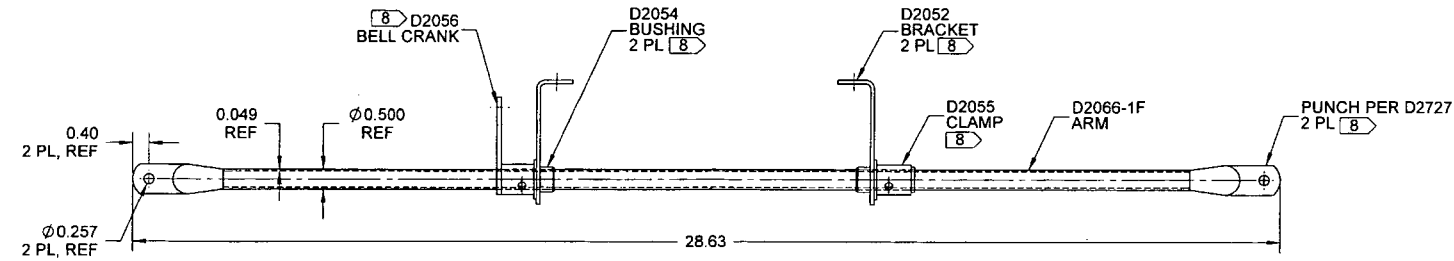


DETAIL B
SCALE 3X
2 PL

SECTION A-A
(SOME PARTS REMOVED FOR CLARITY)



D2066-1 ARM BENDING DETAIL
(MAKE FROM D2066-1F)



D2066-1F ARM CUT LENGTH DETAIL

- NOTES:**
- 1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
 - 8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
 - 9) DRILL $\phi 0.188$ AFTER BENDING

QTY	P/N	DESCRIPTION
X	D2066	ARM
2	D2052	BRACKET
2	D2054	BUSHING
1	D2055	CLAMP
1	D2056	BELL CRANK
1	D2066-1	ARM
4	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW

2510757

RELEASED
08-07-13

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2066	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARM	NTS
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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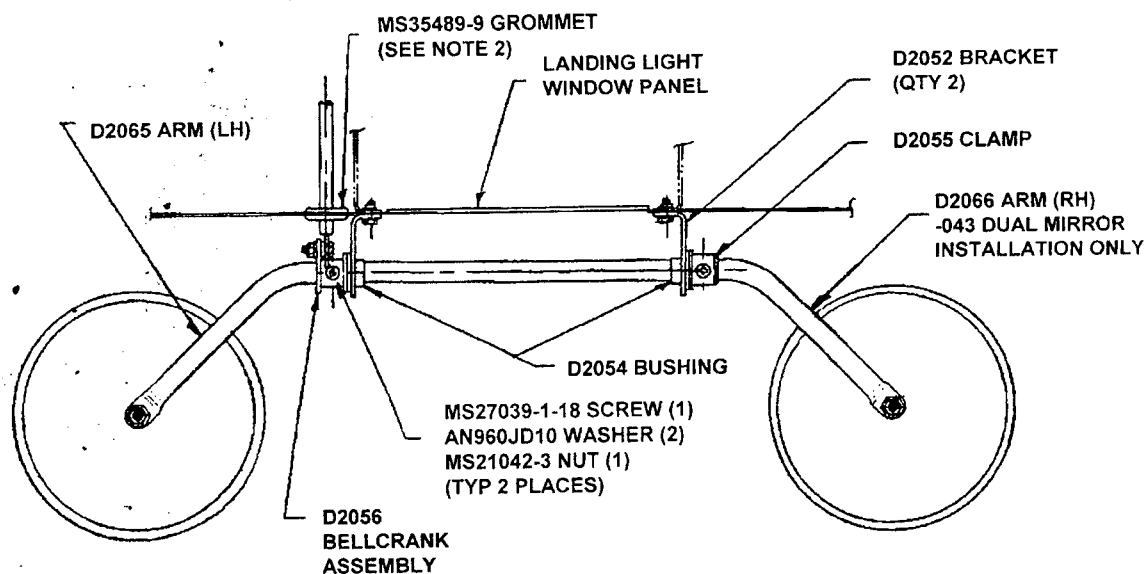


Figure 25.2 - View A: Looking Aft.
(D206-558-043 Mirror Shown)

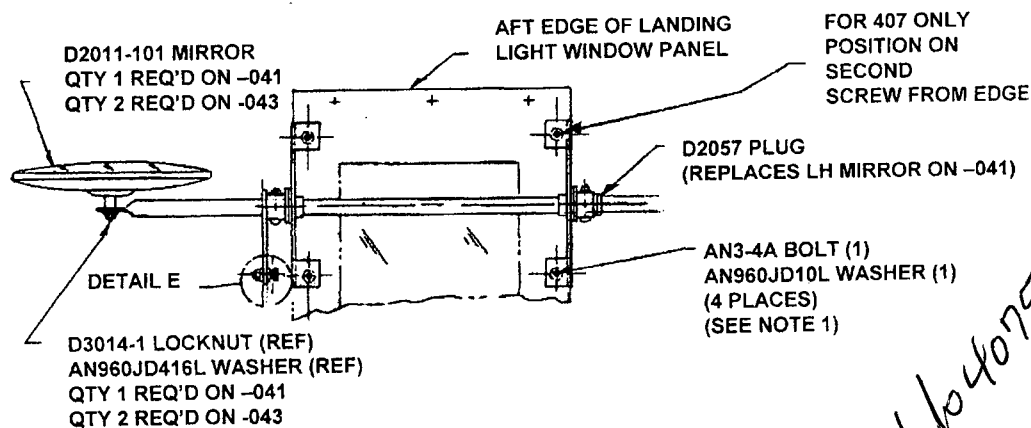


Figure 25.3 - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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25-00-00